Picklist Print

Wednesday, September 07, 2011 1:34:09 PM

Work Order ID: 73609

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step. RH (Folding)

Item	Description	Type
D3454-5	Bushing	Manufactured
D3455-1	Spacer	Manufactured
D3455-3	Spacer	Manufactured
D3462-042	Bracket Assembly	Manufactured

Wednesday, September 07, 2011 1:34:09 PM

Picklist Print

Wednesday, Septembe

Work Order ID: 736

Parent Item: D41

Parent Item Name:

Item	Description
AN5C11	BOLT
AN5C15	BOLT
AN960C516	WASHER
D3454-1	Bushing
D3454-3	Bushing

Wednesday, Septemb

Picklist Print

Wednesday, September

Work Order ID: 7360

Parent Item: D412

Parent Item Name: P

Item	Description
AN3C5A	Bolt
AN44-C12	eyebolt
AN4C15	BOLT

Wednesday, September

Picklist

Wednesday,

Work Order

Parent Item:

Parent Item

Comments:

Component Item Name

Item	Description
AN310-4	NUT
MS24665-302	Cotter Pin
AN310-5	NUT

Pic

Work

Parer

Parer

Item	Description
MS21	Nut
MS24	COTT
NAS1	Washe

Wedi

Work Order ID 73609

Wednesday, September 07, 2011 1:34:13 PM

Item ID: D412-630-032 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Pilot/Co-Pilot Step. RH (Folding)

Start Date: 9/7/2011 **Start Qty:** 2.00

Required Date: 9/23/2011 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr IIN D412-630	**Revision Nbr** Rev M								
100 DC Document Control	DOCUMENT CONTROL	0.00							
	Memo Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003	0.00							
110 Small Fab Small Fab	Small Fab	0.00							
	Memo Assemble as per dwg D412-630 p.17 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.**** A/R MS20995C41 batch: M114830	0.00							
120 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab.	0.00							

P/O →

Conform LJ 12-1-11 (2)

12/01/10 (2)

S 12/01/10

(42)
-032

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ___________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Dart Aerospace Ltd
W/O: DATE STEP PROCEDURE CHANGE
Part No: PAR #: Resolution:
NCR: DATE STEP Description of NC Section A
NOTE: Date & initial all entries
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, September 07, 2011 1:34:09 PM

Work Order ID: 73609

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 9/7/2011 **Required Date:** 9/23/2011

Start Qty: 2.00 **Required Qty:** 2.00

12/1/11

Item	Type		Op	UOM	Qty			Notes
NAS1515H5 Washer	Purchased	No	130	Each	168.0000	1	2	
D3455-1 Spacer	Manufactured	No	110	Each	29.0000	2	4	733002
D3443-041 Strut Weldment Assembly	Manufactured	No	110	Each	0.0000	1	2	B 73612 (10) 72027 1X
D3463-042 Step Weldment Assembly	Manufactured	No	110	Each	0.0000	1	2	B 73616 (20) 12/01/10
D3443-9 Pin	Manufactured	No	110	Each	8.0000	2	4	74699 12/1/10

NAS1515H5 Washer:

Location	Loc Qty	Loc Code
FG	40	
103286	20	
103691	20	
ST277	128	
103286	100	2
118384	28	

D3455-1 Spacer:

Location	Loc Qty	Loc Code
ST054	1	
68469	1	
ST058	28	
72133	28	

D3443-9 Pin:

Location	Loc Qty	Loc Code
ST054	8	
72029	8	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:10 PM

Work Order ID: 73609

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 9/7/2011 **Required Date:** 9/23/2011

Start Qty: 2.00 **Required Qty:** 2.00

AN4C14 Purchased No 110 Each 28.0000 1 2

BOLT

Location		Loc Qty	Loc Code	
ST357		25		
	117688	25		117688
ST358		3		
	114669	3		

MS24665-229 Purchased No 130 Each 307.0000 2 4

COTTER PIN

8 +2

Location		Loc Qty	Loc Code	
GA		200		
	118234	200		118234
ST309		107		
	111041	107		

MS24665-227 Purchased No 110 Each 96.0000 1 2

COTTER PIN

12/07/15 (2)

Location		Loc Qty	Loc Code	
GA		90		
	111041	90		111041
ST309		6		
	113845	6		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:10 PM

Work Order ID: 73609

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 9/7/2011 **Required Date:** 9/23/2011

Start Qty: 2.00 **Required Qty:** 2.00

Item	Type							
AN4CH3 SS Bolt	Purchased	No	110	Each	40.0000	2	4	

Location		Loc Qty	Loc Code	
ST357		40		
	117616	1		
	118131	9		
	118757	10		118757
	118758	20		

Item	Type							
D3465-1 Washer	Manufactured	No	110	Each	7.0000	1	2	73449

Location		Loc Qty	Loc Code
ST054		7	
	46134	7	

Item	Type							
AN310-4 NUT	Purchased	No	130	Each	34.0000	1	2	119328 12/01/08 (2)

Location		Loc Qty	Loc Code
ST324		34	
	118112	34	

Item	Type							
D3443-043 Strut Weldment Assembly	Manufactured	No	110	Each	3.0000	1	2	

Location		Loc Qty	Loc Code	
ST198A		3		12/01/09
	71030	3		B73617 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, September 07, 2011 1:34:10 PM

Work Order ID: 73609

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 9/7/2011 **Required Date:** 9/23/2011

Start Qty: 2.00 **Required Qty:** 2.00

D3454-7
Bushing

Manufactured No 110 Each 14.0000 2 4 73346

Location	Loc Qty	Loc Code
ST058	14	
70528	14	

AN310-7
NUT

Purchased No 110 Each 30.0000 1 2

Location	Loc Qty	Loc Code
ST324	30	
114784	30	114784

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

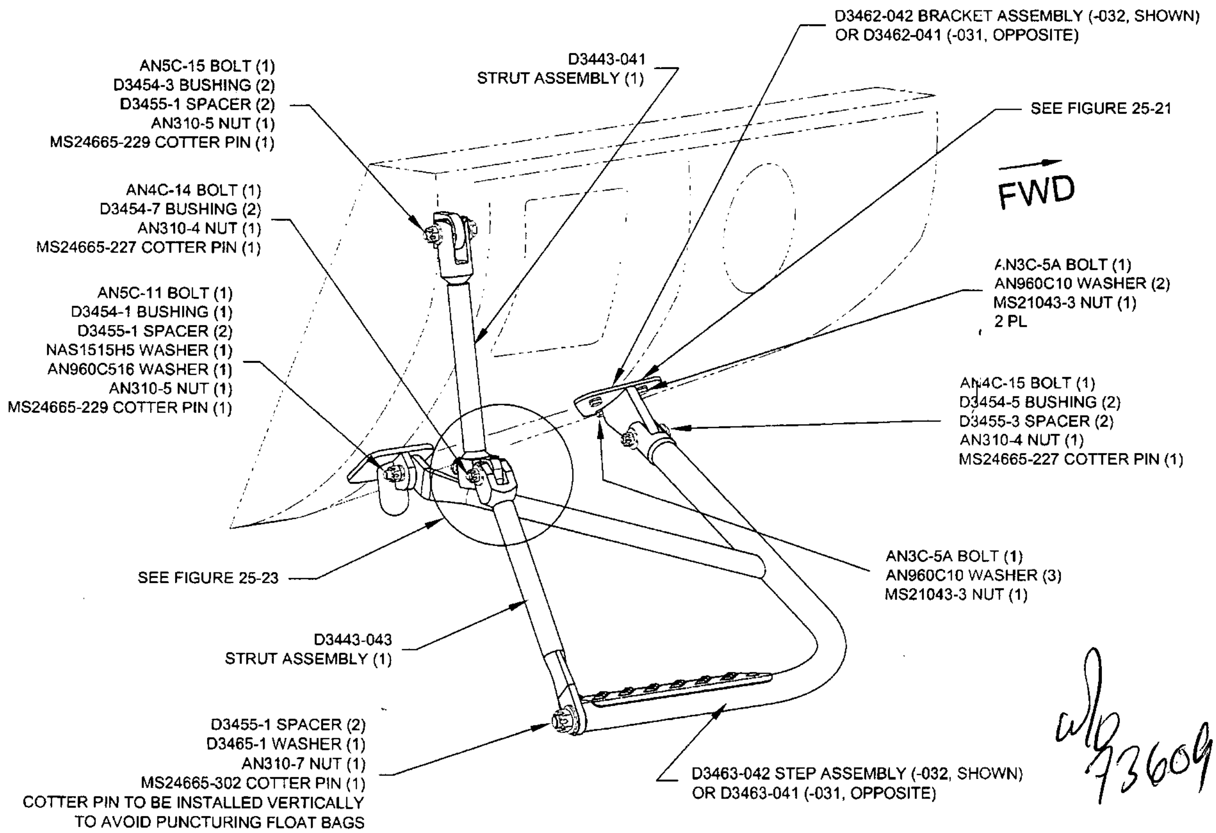


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

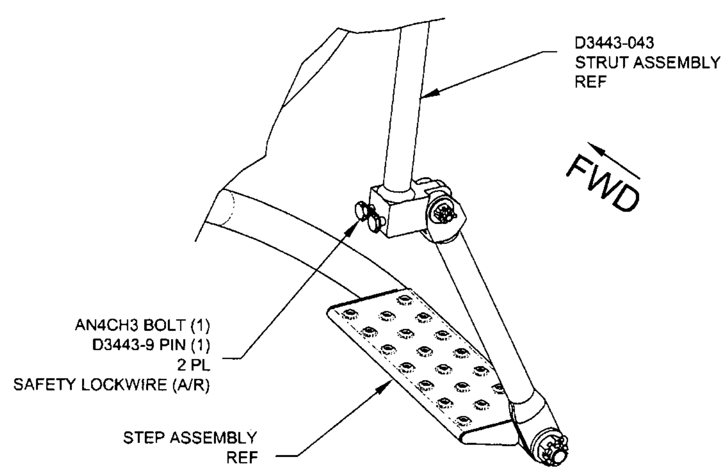


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

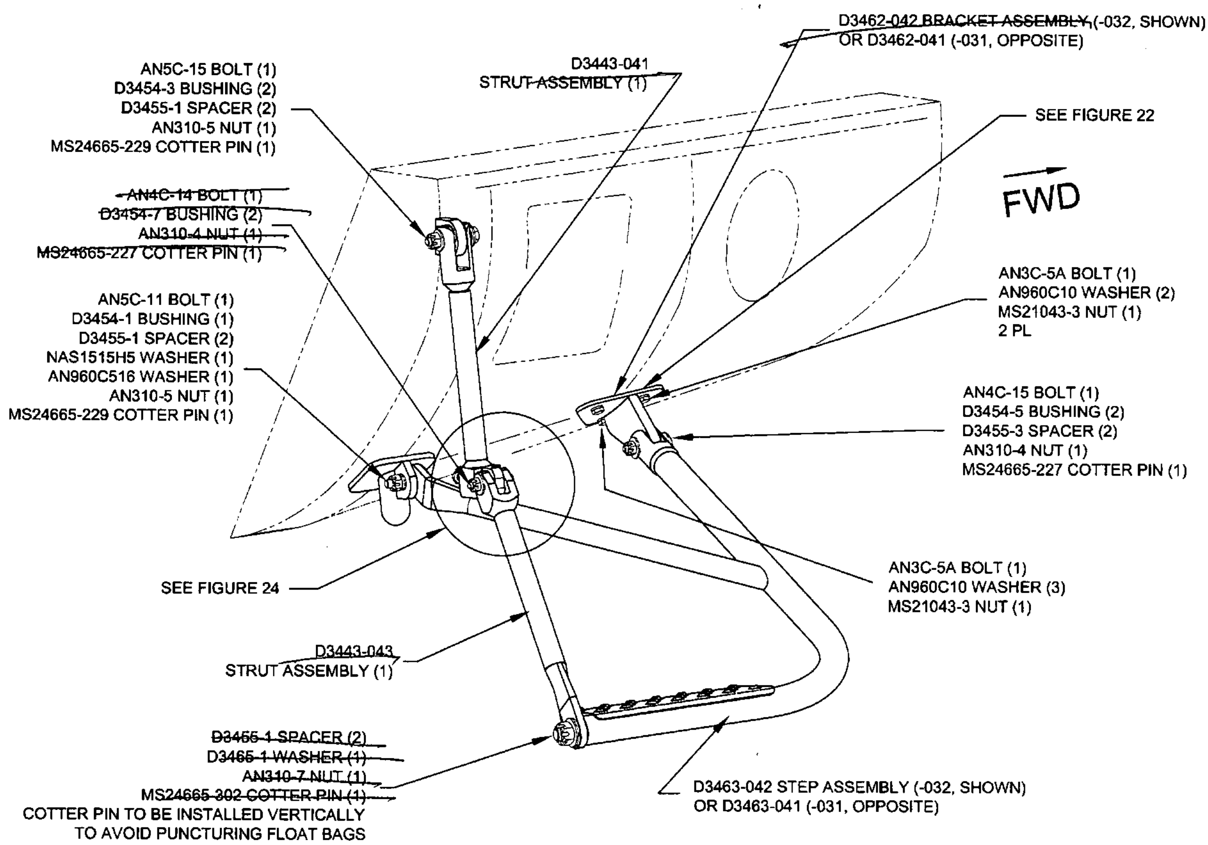


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

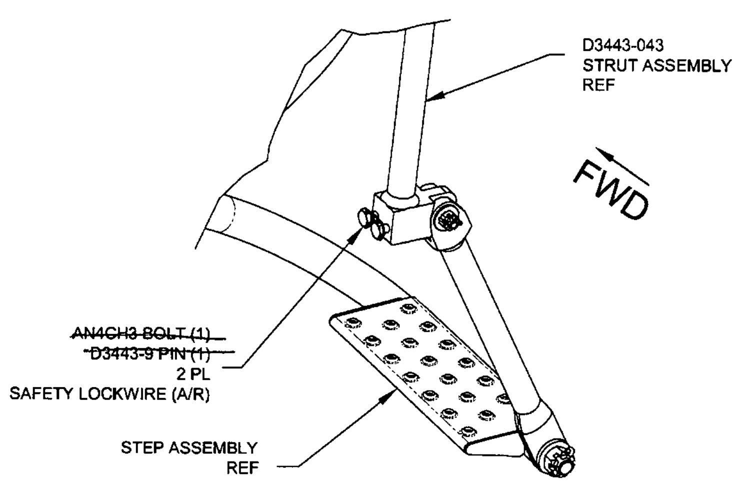
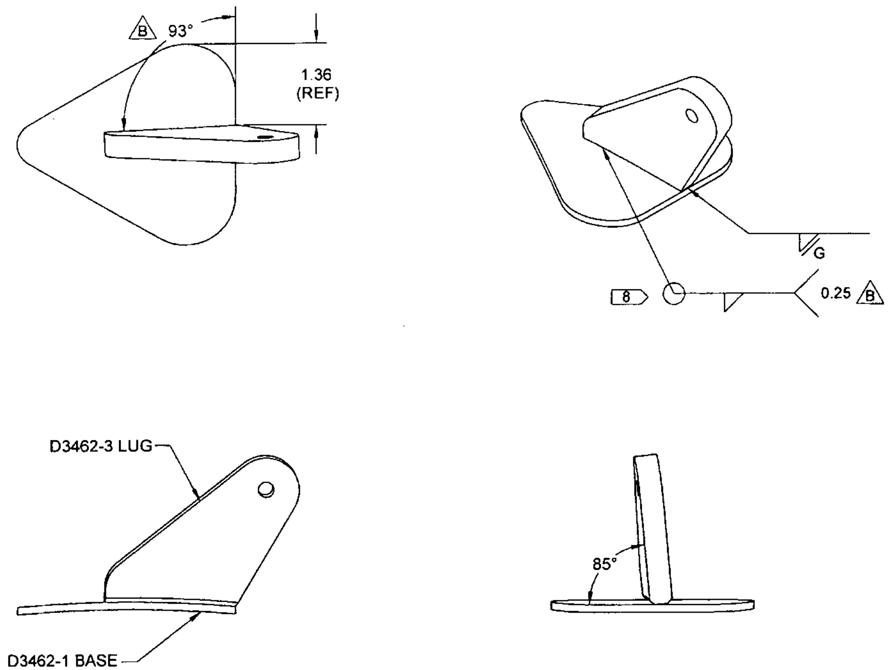


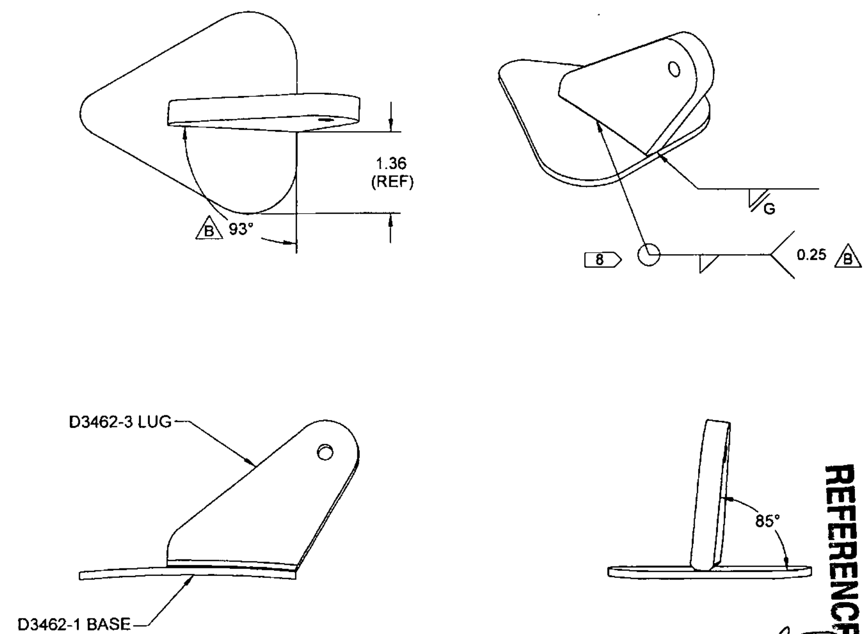
FIGURE 24 – Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

Qty -031	Qty -032	Part Number	Description
X		**D412-630-031**	***PILOT/CO-PILOT STEP*, LH (FOLDING)**
	X	**D412-630-032**	***PILOT/CO-PILOT STEP*, RH (FOLDING)**
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP



D3462-041 BRACKET ASSEMBLY



D3462-042 BRACKET ASSEMBLY

REFERENCE ONLY

RELEASED 08.07.01

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.75 lbs (TYP)
8) WELDING: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
C	SHOW VIEWS OF D3462-041 & D3462-042. UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20

DESIGN	RF
DRAWN	DC
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	07.10.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3462 — REV. C — SHEET 1 OF 2

TITLE: BRACKET ASSEMBLY — SCALE 1:2